

Work Order ID 56526

March 1, 2010 9:28:18 AM



Page 1

Item ID: D2621

Accept



Setup Start



Revision ID:

Item Name: Latch Plate, 350 Spacepod

Stop



Start Date: 3/01/10 Start Qty: 40.00



Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: u

Date:

Tooling:

Date:

Run Start



QC: _____

Date:

SPC (Y/N): _____

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2621

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2621 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-
Deburr if necessary

1B 10-3-10



5652 .0410

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

1B 10-3-10

120

0.00



QC8- Inspect parts - second check

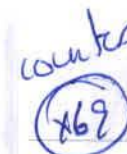
QC

Memo

0.00

Quality Control

S10/03/11



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

OK 10-3-15

(69)

140



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

START TIME:

11:50

3:00 FINISH TIME:

OVEN TEMPERATURE:

12:00

OK 10-3-15

(69) φ

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

Rec'd 3/16 (69)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Cust Item ID:

Required Date: 3/05/10 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 21

0.00



Packaging

Memo

0.00

Packaging

PC 1/4/3/16 (69)

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/17 AG

MF 10-3-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

March 1, 2010 9:28:18 AM

Page 1

Work Order ID: 56526

Parent Item: D2621

Parent Item Name: Latch Plate, 350 Spacepod

Comments: IPP: C02.02.28 Added inspection level 8 and level 5 SM

Start Date: 3/01/10

Required Date: 3/05/10

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M5052H32S.040		Purchased	No			110	sf	79.0568	2.6316			



5052-H32 .040 Sheet



10-3-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	79.0568	
101875	6.625	
104921	3.3568	
106900	2	
107513	4.5	
109058	35.675	
113123	26.9	

113123

69

W/O:		WORK ORDER CHANGES					
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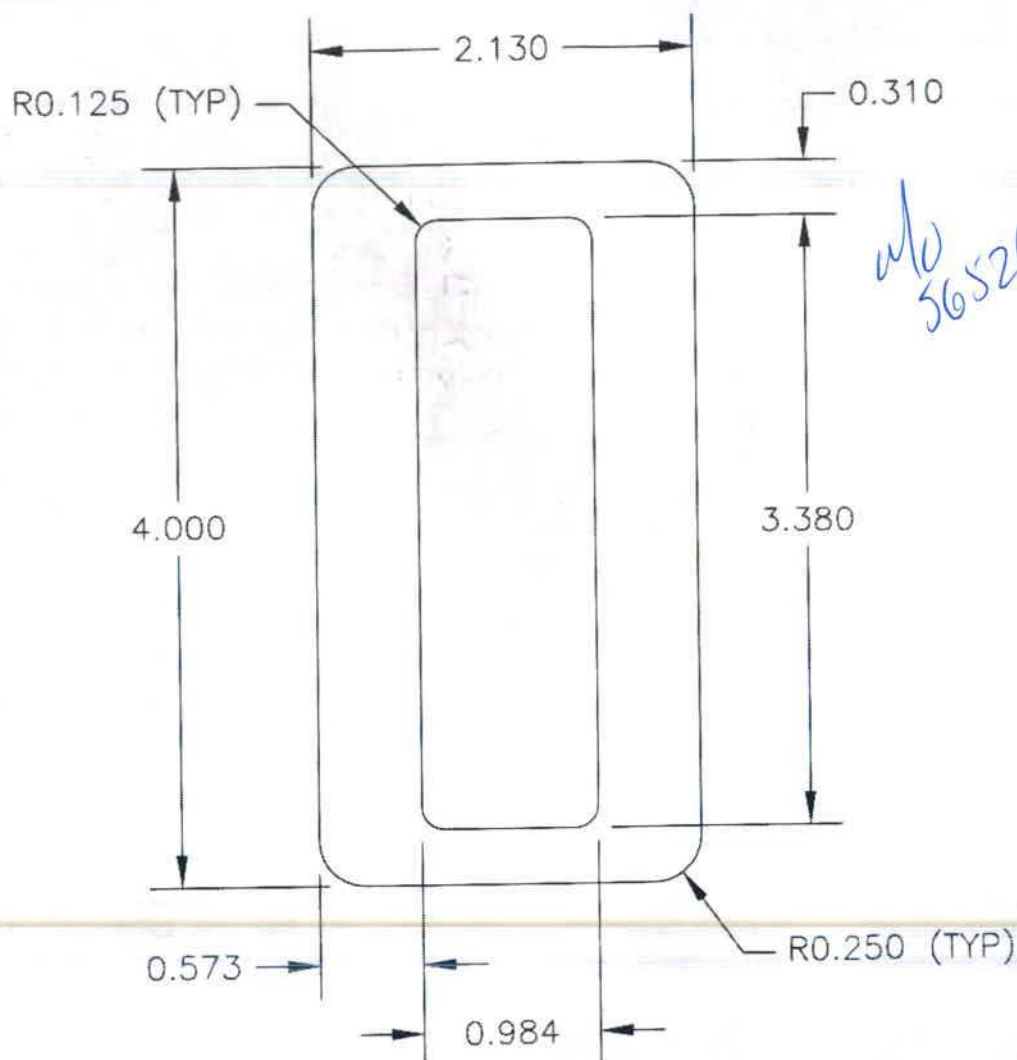
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NOTE: Date & initial all entries

DART

DESIGN BW	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2621	REV. B SHEET 1 OF 1
DATE 00.06.01		TITLE LATCH PLATE	SCALE 1:1
A	96.08.15	NEW ISSUE	
B	00.06.01	ADDED FINISH; R0.125 WAS R0.118	

RELEASED
00.06.05 *[Signature]*

MATERIAL: 5052-H32 (QQ-A-250/8) OR 6061-T6 (QQ-A-250/11) OR 2024-T3
(QQ-A-250/4) 0.040 THICK
FINISH: CHEMICAL CONVERSION COAT PER DART 005 4.1
POWDER COAT BLACK SANDTEX (REF. 4.3.5.7) PER DART QSI 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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